

Amendments to the Claims

This listing of claims replaces all prior versions, and listings, of claims in the application.

Listing of Claims

~~Claim 1.~~ (Currently amended) ~~[[:]]~~ ~~Process~~ A process for the automatic control of the thickness of an extruded ~~films that~~ ~~comprises of the following features~~ film, comprising:

~~Measurement of the~~ measuring a thickness value profile of the ~~film just~~ extruded ~~(8)~~ film with ~~the help of~~ a thickness-measuring probe ~~(12)~~ that is moved along ~~the~~ a surface of the film in a direction (x) that is substantially perpendicular ~~(*)~~ to ~~the~~ a conveying direction (z) of the extruded film, ~~(8)~~. ~~The~~ the thickness-measuring probe ~~records~~ recording for each measuring cycle ~~(MZ)~~ a the thickness value profile ~~(P)~~ of the film ~~(8)~~ at least across parts of ~~the~~ an expansion area of the film ~~(8)~~ in the direction (x) perpendicular ~~(*)~~ to ~~it's~~ the conveying direction (z) ~~[[,]]~~;

~~Transmitting~~ transmitting the measured values to a control unit ~~(14, 15, 17)~~ ~~[[,]]~~;

~~Storage of~~ storing the measured values ~~underlying the~~ ~~thickness profiles~~ in a storage unit ~~(14)~~ ~~[[,]]~~;

~~Provision of~~ determining statistical values of the film thickness ~~(5)~~ using with a computer ~~(14)~~, ~~whereby~~ the computer

~~(14) takes into account~~ accounting for the measured values or information derived therefrom using a ~~definite~~ fixed number ~~(N)~~ of the measuring cycles ~~(MZ)~~ and ~~[[,]]~~ if necessary, provides providing measured values from recent and ~~older~~ previous measuring cycles with different weighting factors, the measured values obtained during a predetermined time-frame at a start of the extrusion process being more heavily weighted by the computer than the measured values obtained during a normal operation subsequent to the predetermined start time-frame;

~~Determination of the~~ determining deviations in the statistical values of the film thickness ~~(5)~~ from a target value ~~[[,]]~~; and

~~Generating~~ generating control commands to a device for controlling the film thickness ~~(5)~~

~~characterized in that~~

~~while providing the statistical values in relation to the older measured values, the latest measured value(s) during a predetermined time frame at the start of the extrusion process are more heavily weighted by the computer (14) than those measured during the normal operation.~~

Claim 2. (Currently amended) ~~[[:]]~~ Process The process pursuant to claim 1 **~~characterized in that~~** wherein the computer ~~(14)~~ determines the statistical values by ~~taking into account~~ accounting for the measured values or the information derived

therefrom using a smaller number ~~(N)~~ of the measuring cycles ~~(MZ)~~ during a the predetermined time-frame at the start of the extrusion process than ~~the~~ a number of the measuring cycles used during the normal operation.

Claim 3. (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 1 ~~characterized in that~~ wherein the computer ~~(14)~~ determines the statistical values during a the predetermined time-frame at the start of the extrusion process ~~wherein~~ and at least one ~~older~~ previously measured value is provided with a smaller weighting factor than the weighing factor used during the normal operation.

Claim 4. (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 1 ~~characterized in that~~ wherein the computer ~~(14)~~ determines the statistical values during a the predetermined time-frame at the start of the extrusion process ~~wherein~~ and at least one ~~recent~~ recently measured value is provided with a larger weighting factor than the weighting factor used during the normal operation.

Claim 5. (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 2 ~~characterized in that~~ wherein at least one of the number ~~(N)~~ of the measuring cycles ~~(MZ)~~ ~~and/or~~ and the weighting factors

after the start of the extrusion process are made to approximate in steps at least one of the number ~~(N)~~ of the measuring cycles ~~(MZ)~~ used in the normal operation ~~and/or~~ and the weighting factors used in the normal operation.

Claim 6. (Currently amended) [[:]] Device A device for the automatic control of the thickness of ~~the~~ an extruded film, ~~(8)~~ having the following features comprising:

a thickness-measuring probe ~~(12)~~ for measuring the that measures a thickness value profile of the ~~film just~~ extruded ~~(8)~~ film that is moved along ~~the~~ a surface of the film ~~(8)~~ in a direction (x) that is substantially perpendicular ~~(x)~~ to ~~the~~ a conveying direction (z) of the extruded film, ~~(8)~~. ~~The the~~ thickness measuring probe ~~(12)~~ records recording for each measuring cycle ~~(MZ)~~ a the thickness value profile ~~(P)~~ of the film ~~(8)~~ at least across parts of ~~the~~ an expansion area of the film ~~(8)~~ in the direction (x) perpendicular ~~(x)~~ to ~~it's~~ the conveying direction (z) [[,]];

~~Transmitting~~ a device that transmits the measured values to a control unit ~~(14, 15, 17)~~ [[,]];

~~A a~~ a storage unit (14) for recording that records the measured values and the information derived therefrom [[,]];

~~A a~~ a computer (14) for providing that determines statistical values of the film thickness ~~(5)~~ taking into account by accounting for the measured values or the information derived

therefrom using a ~~definite~~ fixed number ~~(N)~~ of the measuring cycles ~~(MZ)~~ and using which ~~(14)~~, if necessary, providing measured values from recent and ~~older~~ previous measuring cycles ~~can be provided~~ with different weighting factors, the measured values obtained during a predetermined time-frame at a start of the extrusion process being more heavily weighted by the computer than the measured values obtained during a normal operation subsequent to the predetermined start time-frame, and whereby even the determines deviations in the statistical values of the film thickness ~~(5)~~ from a target value ~~can be determined using the computer (14) [[,]]~~; and

A a device ~~(17)~~ for generating that generates control commands to a device ~~for controlling that controls~~ the film thickness ~~(5)~~

~~characterized in that~~

~~while providing the statistical values in relation to the older measured values the latest measured value(s) from a predetermined time frame at the start of the extrusion are heavily weighted using the computer (14) than during the normal operation.~~

Claim 7. (Currently amended) ~~[[:]]~~ Process ~~The process~~ pursuant to claim 2 ~~characterized in that~~ wherein the computer ~~(14)~~ determines the statistical values during a the predetermined time-frame at the start of the extrusion process ~~wherein~~ and at least one ~~older~~ previously measured value is provided with a

smaller weighting factor than the weighing factor used during the normal operation.

~~Claim 8.~~ (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 2 ~~characterized in that~~ wherein the computer ~~(14)~~ determines the statistical values during a the predetermined time-frame at the start of the extrusion process ~~wherein~~ and at least one ~~recent~~ recently measured value is provided with a larger weighting factor than the weighting factor used during the normal operation.

~~Claim 9.~~ (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 3 ~~characterized in that~~ wherein the computer ~~(14)~~ determines the statistical values during a the predetermined time-frame at the start of the extrusion process ~~wherein~~ and at least one ~~recent~~ recently measured value is provided with a larger weighting factor than the weighting factor used during the normal operation.

~~Claim 10.~~ (Currently amended) [[:]] ~~Process~~ The process pursuant to claim 3 ~~characterized in that~~ wherein at least one of the number ~~(N)~~ of the measuring cycles ~~(MZ)~~ and/or and the weighting factors after the start of the extrusion process are made to approximate in steps the number ~~(N)~~ of the measuring cycles ~~(MZ)~~

used in at least one of the normal operation ~~and/or~~ and the weighting factors used in the normal operation.

~~Claim~~ 11. (Currently amended) ~~[[:]]~~ ~~Process~~ The process pursuant to claim 4 ~~characterized in that~~ wherein at least one of the number ~~(N)~~ of the measuring cycles ~~(MZ)~~ ~~and/or~~ and the weighting factors after the start of the extrusion process are made to approximate in steps at least one of the number ~~(N)~~ of the measuring cycles ~~(MZ)~~ used in the normal operation ~~and/or~~ and the weighting factors used in the normal operation.